

Work Order ID 83596

Friday, April 20, 2012 9:02:33 AM

83596

Page 1

Item ID: D3339-9

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad Aft

Start Date: 4/20/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/30/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *P*

Date: *12-04-20* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision-Nbr
D3339	B

100		0.00
-----	--	------

100

PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev *B*

Prog Rev *B*

2-Debur if necessary

1010 063

110	QC2-Inspect parts off machine FAI/FAIB	0.00
-----	--	------

110

QC

Memo

0.00

Quality Control

120	QC8-Inspect parts - second check	0.00
-----	----------------------------------	------

120

QC

Memo

0.00

Quality Control

Salazar

(Signature)

Jim 12-5-22

Jim 12-5-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Friday, April 20, 2012 9:02:34 AM

Item ID: D3339-9 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad Aft
 Start Date: 4/20/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 4/30/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00				(4)			S 2/6/04
130	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary								
	2-Form as per Dwg D3339 using DT8326 and DT8261								
140		0.00				(4)			
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00				(x4)			
150	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld Hard coat 7560 per Dwg D3339, use DT8210 & DT8810 Layout								
	Jig A/R 7560 Hardcoat Batch: m121003								

ME 12-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Friday, April 20, 2012 9:02:34 AM

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Required Date: 4/30/2012 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				(44)			
170 *170* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 3:30 FINISH TIME: 4:00 OVEN TEMPERATURE:	0.00 0.00				4X			M.L. 12/17/24
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4			BLD 7-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83596***83596***

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Identify as per dwg & Stock Location: ST

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

44
SP
127-25
MLJ 12/07/25
MLJ 12/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, April 20, 2012 9:02:38 AM

Page 1

Work Order ID: 83596

83596

Parent Item: D3339-9

D3339-9

Parent Item Name: Wearpad Aft

Start Date: 4/20/2012

Required Date: 4/30/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.04.19 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	141.8200	0.078	0.328421			

M1010S16GA

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

141.82

116791

16.8

117500

16.02

118965

30

121195

79

116791

Jm

12-5-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

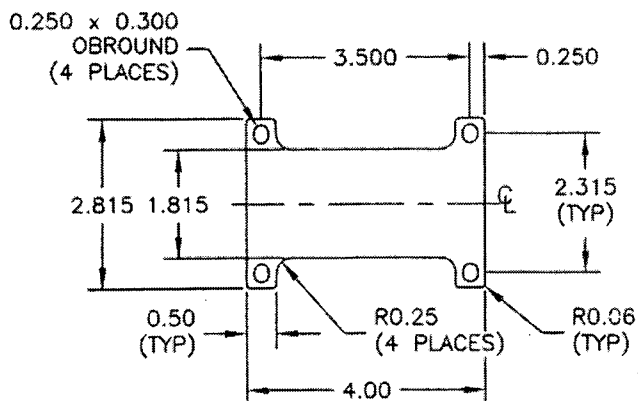
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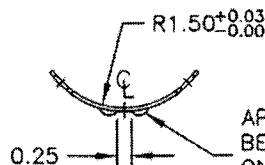


RELEASED
05.11.22

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. B SHEET 1 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:3
A	05.06.06	NEW ISSUE	
B	05.11.22	CORRECTED HOLE SPACING D3339-7F	



D3339-1F FLAT PATTERN



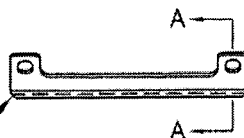
SECTION A-A

APPLY 7560 HARDCOAT WELD BEADS, 0.063 TO 0.125 THICK, ON BOTTOM SURFACE AFTER FORMING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *93594*

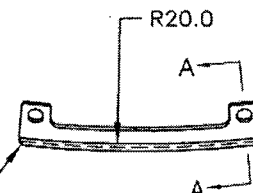
11204-2 d

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-3T1
AFTER FORMING
(SEE SECTION A-A)



D3339-3 CENTER WEARPAD
(MADE FROM D3339-1F)

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-5T1
AFTER FORMING
(SEE SECTION A-A)



D3339-5 FORWARD WEARPAD
(MADE FROM D3339-1F)

D3339-1F/-3/-5 WEARPAD

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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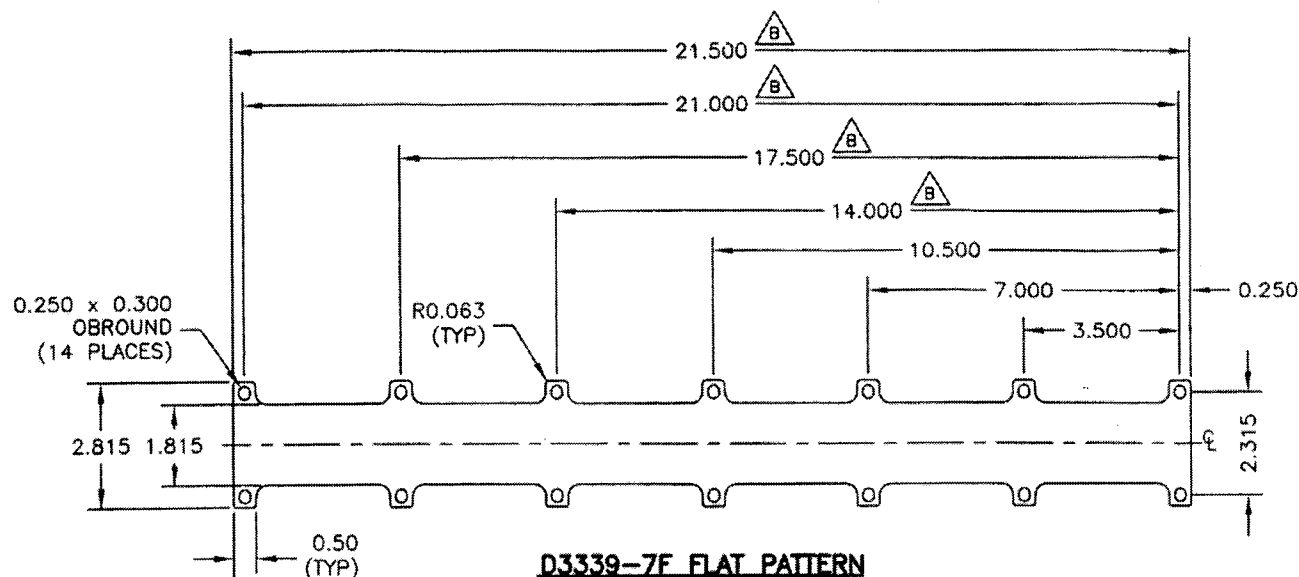
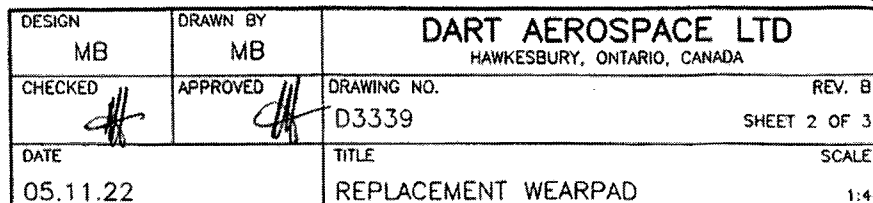
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

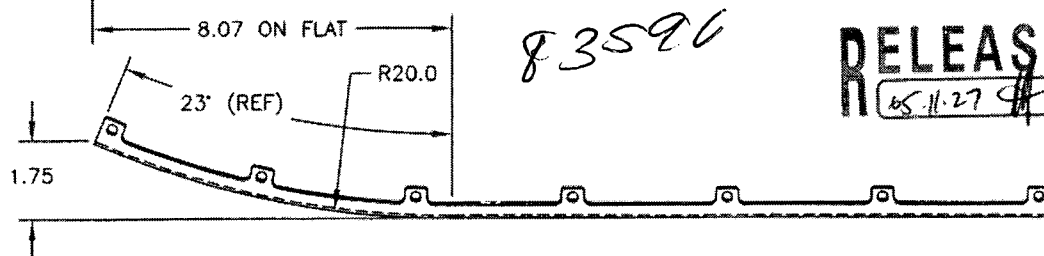
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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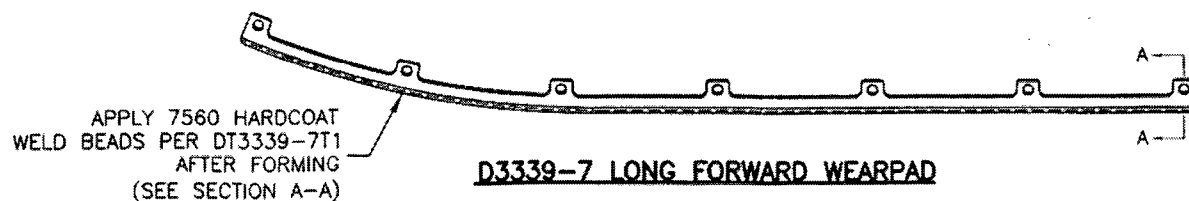
NOTE: Date & initial all entries



D3339-7F FLAT PATTERN



D3339-7B LONGITUDINAL BEND



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
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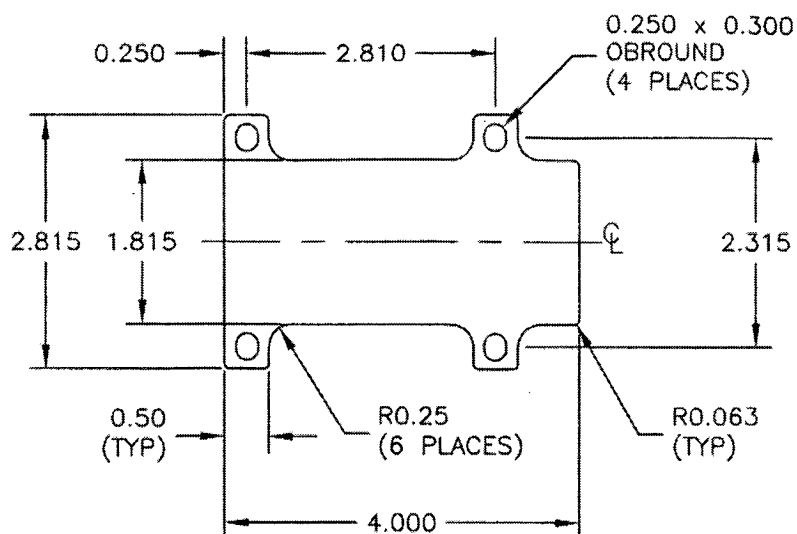
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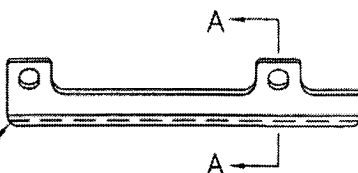
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. B SHEET 3 OF 3
DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:2



D3339-9F FLAT PATTERN

RELEASED
05.11.22

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-9T1
AFTER FORMING
(SEE SECTION A-A)



D3339-9 AFT WEARPAD

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
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